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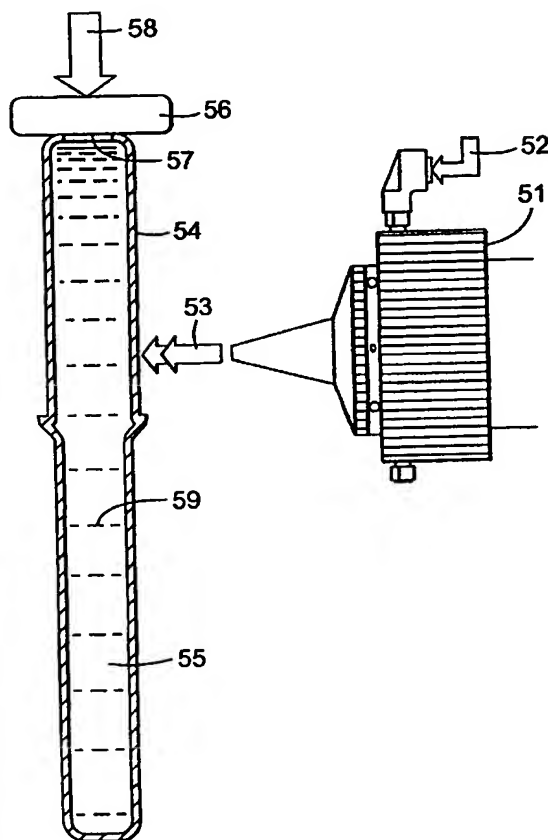
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(54) Title: MANUFACTURE OF VALVE STEMS

(57) Abstract: A method for providing a hole into a valve compo-  
nent having an internal cavity (55), said method comprising the steps  
of filling and sealing a fluid (59) within said cavity; and laser drilling  
the hole through the component into the internal cavity. Said method  
is particularly advantageous for providing a side port into a valve stem  
(54). The present invention also relates to a method of manufactur-  
ing a valve stem, said method comprising the steps of: a) providing  
a valve stem work-piece having a passageway with an outlet (57);  
b) filling the passageway with a fluid; c) sealing the outlet; d) laser  
drilling a side port through the work-piece into the passageway; and  
e) unsealing the outlet.

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